

**ENGINEERING DIRECTIVES AND STANDARDS**

Volume : III                      Effective Date :  
Chapter : 1                      Revision Date : 01/21/2004  
Section : 1                      Subject : **CERTIFICATION OF ASPHALTIC CONCRETE PLANS AND  
DIRECTIVE : 16                      PORTLAND CEMENT CONCRETE PLANTS**

**1. PURPOSE:**

The purpose of this directive is to establish the requirements for certification of asphaltic concrete plants and portland cement concrete plants.

**2. SCOPE:**

Certification is a requirement of asphaltic concrete plants and portland cement concrete plants, including prestressed concrete plants, which supply the Department with mixes for construction projects. Excluded from this requirement are concrete pipe plants and plants supplying portland cement concrete for minor structures.

**3. REQUIREMENTS:**

- a. The District Laboratory Engineer is responsible for inspecting and certifying plants in his district before they may supply mix for construction projects. The Structural Fabrication Engineer is responsible for inspecting and certifying plants that produce strictly for precast and prestressed concrete products. When inspecting asphaltic concrete plants, the District Laboratory Engineer will use Form 03-22-3075, Bituminous Hot Mix – Batch Plant Inspection Report. Evaluations required by the inspection form are to be based on Departmental specifications for asphaltic concrete plants.

When inspecting portland cement concrete plants, the District Laboratory Engineer will use Forms 03-22-4030 and 03-22-4045, Portland Cement Concrete Plant Inspection Report and Portland Cement Concrete Truck Certification Report, again making evaluations according to Departmental specifications; and, in addition to covering the areas outlined on the form, he shall check the calibration of water dispensers on transit mixers.

When inspecting portland cement concrete plants, used strictly for precast and prestressed products, the Structural Fabrication Engineer will use Forms 03-22-4030 and 03-22-4045, Portland Cement Concrete Plant Inspection Report and Portland Cement Concrete Truck Certification Report, again making evaluations according to Departmental specifications; and, in addition to covering the areas outlined on the form, he shall check the calibration of water dispensers on transit mixers.

- b. If a plant does not meet the requirements outlined in the proper inspection report, the District Laboratory Engineer or Structural Fabrication Engineer must notify the plant owner, in writing, giving the reasons for failure. If deficiencies are minor, the contractor may supply mix for 30 days, during which time the deficiencies must be corrected in order for the plant to be certified. The Department will not accept mix from a plant whose deficiencies are major or whose minor deficiencies have not been corrected within the 30-day grace period. If transit mixers are rejected, the District Laboratory Engineer should give the contractor a list of the rejected trucks and the reasons for their rejection.

Certification is valid for two years; however, the District Laboratory Engineer or Structural Fabrication Engineer may revoke if he finds shortcomings at interim inspections of the plant and the contractor does not correct them within 30 days. In addition, the truck units used to transport concrete (transit mixers or non-agitating units) will be inspected prior to the beginning of each project and periodically for the project duration by the District Laboratory Engineer to assure continued compliance.

The contractor should be notified in accordance with the provisions of Page 1, Paragraph 3(b), if any truck units are rejected during these periodic inspections.

- c. The District Laboratory Engineer or Structural Fabrication Engineer must keep a file of all certified plants under their jurisdiction. Each file should have the plant name, number, location and certification dates for all measuring equipment.
- d. Certification requires that independent companies specializing in their field calibrate all measuring devices. When a plant is furnishing material for a state project, the scales, water meter and admixture dispensers are to be calibrated every 90 days or when changes are made or as required by the Engineer. During periods in which a certified plant is not providing material for any state project, these calibration checks are not required. When a certified plant has been idled for 90 days or more, the scales, water meters and admixture dispensers must be recalibrated before operations for state projects can be recommended. A plant which has been certified for one state project, and meets all certification criteria, may furnish material for concurrent state projects without additional certification.
- e. When a plant is moved, the plant must be re-calibrated to verify that all certification requirements are met. Scales, admix dispensers, and water meters must be recalibrated with documentation forwarded to the District Laboratory; or, for precast and prestressed plants, forwarded to the Structural Fabrication Engineer.

**4. OTHER ISSUANCES AFFECTED:**

All directives, memoranda or instructions issued heretofore in conflict with this directive are hereby rescinded. This directive replaces EDSM 111.1.1.16 dated 3/1/78.

**5. EFFECTIVE DATE:**

This policy will become effective upon receipt.

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CHIEF ENGINEER